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UCHIKOSHI KUNIO(54) METHOD AND DEVICE FOR CONTROLLING
WIRE FEEDINGetc. caused by the slipping and buckling of the wire 2
as in ordinary cases may be eliminated.

(57) Abstract:

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PURPOSE: To smoothly feed wire with an extremely simple constitution by changing the position of the flexible free end of the wire guide pipe provided between a push feeder and pull feeder and detecting the deflection of the wire from the change amount thereof.

CONSTITUTION: The welding wire 2 coiled on a wire reel 1 is let off by a push feeder 3 and is fed into a pull feeder 5 through a wire guide pipe 4 which is made partly flexible, thence it is further sent to a welding torch 6. Here, the deflection amount of the wire 2 being fed in the pipe 4 is detected from the change amount of the input voltage supplied to the input end of a phase controller 19, so that the rotating speed of the push power device 13 of the feeder 3 is controlled. Hence, even when there are fluctuations in the consumption amount and load of the wire 2, the correct deflection amount of the wire 2 is maintained at all times. As a result of this, the feed speed of the feeder 3 is synchronized to the feed speed of the feeder 5, by which the wire 2 is smoothly fed up to the torch 6. Namely, the welding defects, the damaging of the welding device,

